

# Work Order ID 63584

Thursday, November 04, 2010 1:06:13 PM



Page 1

Item ID: D2932-1

Accept



Setup Start



Revision ID:

Item Name: Saddle LH Out, 206

Stop



Start Date: 11/4/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 11/12/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

*[Signature]*

Date: 10-11-04

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D2932	Rev C								
100	HAAS CNC VERTICAL MACHINING #1	0.00							
	HAAS 1								
HAAS CNC vertical machine #1	<b>Memo</b>	0.00							
	Program part number and batch number. <input type="checkbox"/> 1-Inspect part number and batch number are programmed correctly. <input type="checkbox"/> 2-Machine Step No 1 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet <input type="checkbox"/> 3-Machine Step No 2 of Folio and visually inspect as per								
110	CONVENTIONAL MILLING MACHINE	0.00							
	Mill Conv								
Conventional Milling Machine	<b>Memo</b>	0.00							
	Machine Keyway and inspect per attached dimension sheet								
120	QC1- Inspect dimensions to dimension sheet	0.00							
	QC								
Quality Control	<b>Memo</b>	0.00							

*ml 10.12.3*

*6*

*ml 10.12.3*

*6*

*ml 10.12.3*

*6*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 63584

Thursday, November 04, 2010 1:06:13 PM



Page 2

Item ID: D2932-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle LH Out, 206

Start Date: 11/4/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 11/12/2010 Req'd Qty: 6.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

QC8- Inspect parts - second check

0.00

*aml 10/12/03*



QC

Memo

0.00

Quality Control

6 0 \_\_\_\_\_

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

6 BL 10-12-6

150

White Gloss(Ref.4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

*M115951*

START TIME: 10.00 OVEN TEMPERATURE:  
320° FINISH TIME: 10.30

6 BL 10-12-7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 63584**

Thursday, November 04, 2010 1:06:13 PM

Page 3

Item ID: D2932-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Saddle LH Out, 206

Start Date: 11/4/2010 Start Qty: 6.00

Cust Item ID:

Required Date: 11/12/2010 Req'd Qty: 6.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC3- Inspect Part Finish

0.00

7/20

10/12/07

6 0



QC

Memo

0.00

Quality Control

170

Identify as per dwg &amp; Stock Location: 428

0.00



Packaging

Memo

0.00

Packaging

10/12/08

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/12/08  
MF  
10-12-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Thursday, November 04, 2010 1:06:17 PM

Page 1

Work Order ID: 63584

Parent Item: D2932-1

Parent Item Name: Saddle LH Out, 206



Start Date: 11/4/2010

Required Date: 11/12/2010

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP: B 00.06.26 New DWG rev (mpp 2069) EC  
IPP Rev: C As per Rev C 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D6101-003		Manufactured	No			100	Each	24.0000	1	6			
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Saddle Billet, 7075



10-12-3

Location

Loc Qty

Loc Code

MAT042

24

61250

24

63584

(CXC)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	63584
<b>Description:</b> 206 Saddle, Outboard, Left side	<b>Part Number:</b>	D2932-1
<b>Inspection Dwg:</b> D2932 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5	6
A	0.100	0.140	Verify	.120	.120	.120	.120	.120	.120
B	0.100	0.140	OK - 02	.120	.120	.120	.120	.120	.120
C	0.100	0.140		.125	.125	.125	.125	.125	.125
D	0.210	0.230		.220	.220	.220	.220	.220	.220
E	1.245	1.255		1.250	1.250	1.250	1.250	1.250	1.250
F	1.245	1.255		1.250	1.250	1.250	1.250	1.250	1.250
G	2.495	2.505		2.500	2.500	2.500	2.500	2.500	2.500
H	0.510	0.515		.513	.513	.513	.513	.513	.513
I	1.572	1.582		1.577	1.577	1.577	1.577	1.577	1.577
J	2.495	2.505		2.500	2.500	2.500	2.500	2.500	2.500
K	0.257	0.262		.257	.257	.257	.257	.257	.257
L	0.312	0.317		.314	.314	.314	.314	.314	.314
M	0.235	0.240		.237	.237	.237	.237	.237	.237
N	0.100	0.140		.115	.115	.115	.115	.115	.115
O	0.540	0.560		.550	.550	.550	.550	.550	.550
P	0.490	0.510		.502	.502	.502	.502	.502	.502
Q	3.715	3.725		3.720	3.720	3.720	3.720	3.720	3.720
R	2.470	2.510		2.491	2.491	2.491	2.491	2.491	2.491
S	0.240	0.270		.250	.250	.250	.250	.250	.250
T	0.100	0.180		.130	.130	.130	.130	.130	.130
U	1.625	1.635		1.630	1.630	1.630	1.630	1.630	1.630
V	1.362	1.372		1.367	1.367	1.367	1.367	1.367	1.367
W	0.316	0.321		.316	.316	.316	.316	.316	.316
X	1.125	1.145		1.135	1.135	1.135	1.135	1.135	1.135
Y	1.565	1.585		1.575	1.575	1.575	1.575	1.575	1.575
Z	0.178	0.198		.188	.188	.188	.188	.188	.188
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	me
Date:	10.12.3

Audited by:	me
Date:	10/12/03

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

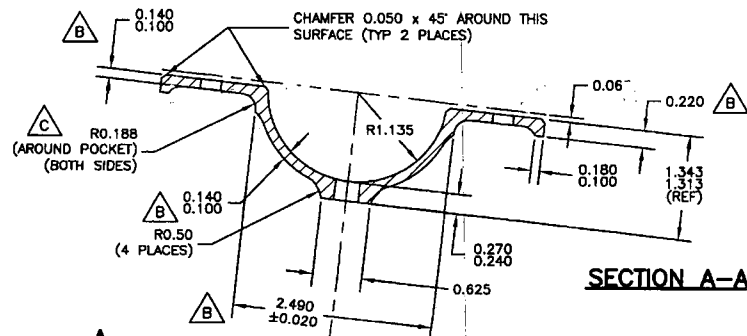
**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

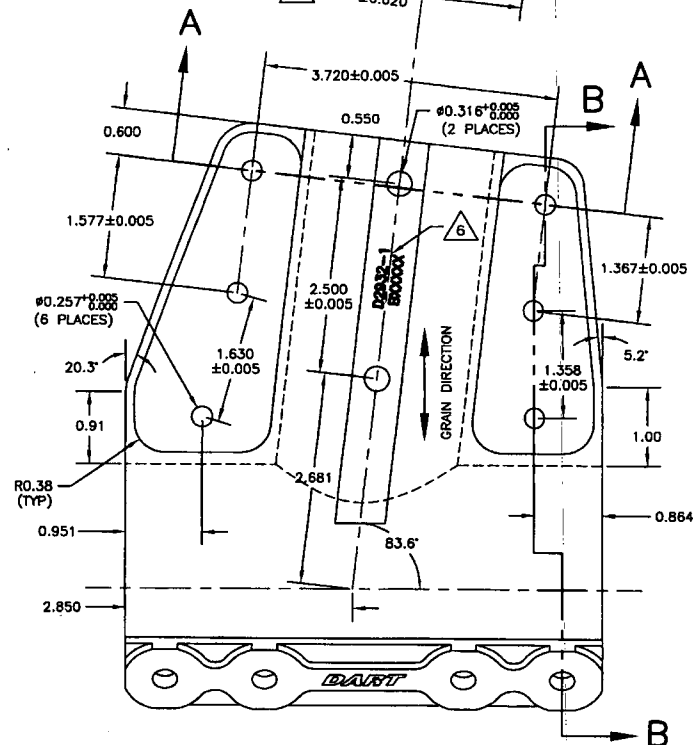
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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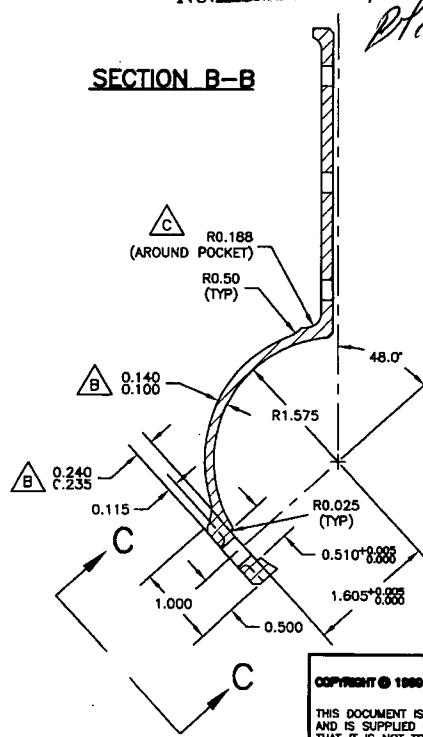
**NOTE:** Date & initial all entries



SECTION A-A



SECTION B-B



VIEW C-C

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 63584

07-11-04

D2932-1 LH SADDLE (SHOWN)  
D2932-2 RH SADDLE (OPPOSITE)

- NOTES:
- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)  
(MAKE FROM D6101-003 SADDLE BILLET, 7075)
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
  - 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
  - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
  - 5) ALL DIMENSIONS ARE IN INCHES
  - 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.10.29	NEW ISSUE
DESIGN	BY	DRAWN BY
CHECKED	PH	APPROVED
DATE	06.11.09	TITLE
		SADDLE OUTSIDE

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PERSON WITHOUT WRITTEN PERMISSION FROM  
DART AEROSPACE USA, INC.

DART DART AEROSPACE USA, INC.  
BELLINGHAM, WA

DRAWING NO.  
D2932  
SHEET 1 OF 1  
SCALE  
2:3

RELEASED  
07-02-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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